Work Order ID 98124

*March-07-13 1:05:10 PM

98124

Item ID: D119-646-212 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: UR W **Stop** *NS2*

Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/07/13 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 3/07/13 **Req'd Qty:** 1.00 *1* **Customer:**

Reference: REWORK-ECN13-534

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
IIN-D119-646	B								
100		0.00							
100									
DC	**Memo**	0.00							
Document Control	Photocopy bluefile &type labels per PPP D119-646-212 CHG004 PER ECN13-534								
101		0.00							
101									
HandFinish	**Memo**	0.00							
Hand Finishing	PULL FROM STK: 1 X D119-646-212 B91626 REMOVE FWD CAP, PUT ASIDE TO RE-INSTALL								
102		0.00							
102									
Skidtubes	**Memo**	0.00							
Skidtubes	COUNTERSINK FWD MOST HOLES TO 0.385 X 100DEG ON BOTH SIDES PER DSI 9594 DEBURR								

DART
Dart Aerospace Ltd.
1270 ABERDEEN ST.
HAWKESBURY, ON, CANADA K6A 1K7
TC APPROVAL # 09-89
TEL: 1-613-632-5200

P/N	D119-646-212	CHG	CHG003
DESC.	Skidtube STD, RH	STC	SR02024SE
LOT	B91626	STC	
MODEL	Agusta A119/AW119MKII	STC	

PATENTS US #5735484, CA #2222184 EUROPEAN No. #0828655 MADE IN CANADA 02729-2

for MCJ 13-3-12

13-3-11

B98124 RH

Item ID: D119-646-212 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: U/R **Stop** *NS2*
Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/07/13 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 3/07/13 **Req'd Qty:** 1.00 *1* **Customer:**
Reference: REWORK-ECN13-534

Run Start *NR1* **Stop** *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
103	QC5- Inspect part completeness to step on W/O	0.00							
103									
QC	**Memo**	0.00							
Quality Control									
104		0.00							
104									
HandFinish	**Memo**	0.00							
Hand Finishing	-RE-ALODINE AFFECTED AREAS -TOUCH UP WITH IMRON								
105	QC3- Inspect Part Finish ✓	0.00							
105									
QC	**Memo**	0.00							
Quality Control									

DAS 16 3/3/14

IRH ✓ 13/03/a1

1 ✓ 13-3-11

Item ID: D119-646-212 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: U/R **Stop** *NS2*
Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/07/13 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 3/07/13 **Req'd Qty:** 1.00 *1* **Customer:**
Reference: REWORK-ECN13-534

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
106		0.00							
106						IRR	f	11	13/03/11
HandFinish	**Memo**	0.00							
Hand Finishing	REPLACE FWD CAP USING MS24694-C52 SCREWS SIKAFLEX B AA123444								
107	QC5- Inspect part completeness to step on W/O	0.00	DAS 16						13/3/12
107									
QC	**Memo**	0.00							
Quality Control									
110	Pick Kit	0.00							
110						DAS 06			13/3/20
Packaging	**Memo**	0.00							
Packaging	ENSURE ORIGINAL KIT IS IN BOX								

Item ID: D119-646-212 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: U/R **Stop** *NS2*
Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 3/07/13 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 3/07/13 **Req'd Qty:** 1.00 *1* **Customer:**
Reference: REWORK-ECN13-534

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00				1			
120									
QC	**Memo**	0.00 13320							
Quality Control									
130		0.00							
130									
Packaging	**Memo**	0.00							
Packaging	REPACKAGE PER PPP USING NEW B/N @ CHG004 NEW LABELS AND DSI PAPERWORK REQ'D Identify and pack for shipping as per PPP D119-646-212 Location:_____ PPP rev:_____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	**Memo**	0.00							
Quality Control									

DAS 2-7 — DAS 06 2-8 — 3/3/20 — MLJ 13-03-21

W 130324

Picklist Print

March-07-13 1:05:09 PM

Work Order ID: 98124

Parent Item: D119-646-212 **Start Date:** 3/07/13 **Required Date:** 3/07/13

Parent Item Name: Skidtube STD w/ Training Wearplates, RH **Start Qty:** 1.00 **Required Qty:** 1.00

Comments: IPP RevA: New issue DD verified by:EC IPP Rev:B 12.09.12 as per ECN12-644 DD verf:JLM IPP REV:C 12.11.05 raise to chg003 (ECN 12-675) DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-646-212 Skidtube STD w/ Training Wearplates, RH		Manufactured	No				Each	0.0000		1	91626		
MS24694-C52 Screw		Purchased	No				Each	192.0000		2	JL 13/03/11		

Location	Loc Qty	Loc Code
ST301	192	
124291	92	X2
124308	100	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-646 REV. B,
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-646 REV. 1 OR EARLIER,
REF. FAA STC SR02024SE

1.0 PURPOSE

The purpose of this DSI is to provide instructions for customers to modify the forward end of the D119-646-XXX skidtubes using the DSI 9594-011 Kit to make the skidtubes compatible with the Agusta ground handling wheels. One kit modifies 2 skidtubes. After CHG 001, portions of this modification may have been incorporated in production and therefore will not need to be incorporated in the field.

2.0 PROCEDURE

Modify the skidtubes as follows:

2.1 Rotate the D3407-041 Tow Ring to the vertical position as necessary.
2.2 Mark holes in the center ridge as shown in Figure 1. Drill through skidtube with Ø0.500" (12.7 mm drill), and countersunk to Ø0.650 x 100°, two places per side.
2.3 Remove and discard the hardware retaining the forward Cap. Countersink the existing holes to Ø0.385 x 100°.
2.4 Deburr holes. Touch up affected areas with chemical film material (Alodine 1200 or 1201) per MIL-C-5541.
2.5 Bond D2579 spacers into the Ø0.500 holes center in the skidtube using Magnobond 6398. Grind flush prior painting as shown in Figure 1.
2.6 Apply one coat of MIL-P-85582 or MIL-P-2337 primer and 2-3 coats of MIL-C-83285 polyurethane coat to match original finish.
2.7 Fasten the forward Cap using MS24694-C52 Screws. Seal threads with Proseal 890. Ensure that screw heads sit below skidtube surface
2.8 Repeat steps 2.1 to 2.7 for opposite skidtube.

3.0 PART LIST

Qty -011	PART NUMBER	DESCRIPTION
X	DSI 9594-011	FWD GROUND HANDLING SPACER KIT
4	D2579	CROSS BOLT SPACER
4	MS24694-C52	SCREW

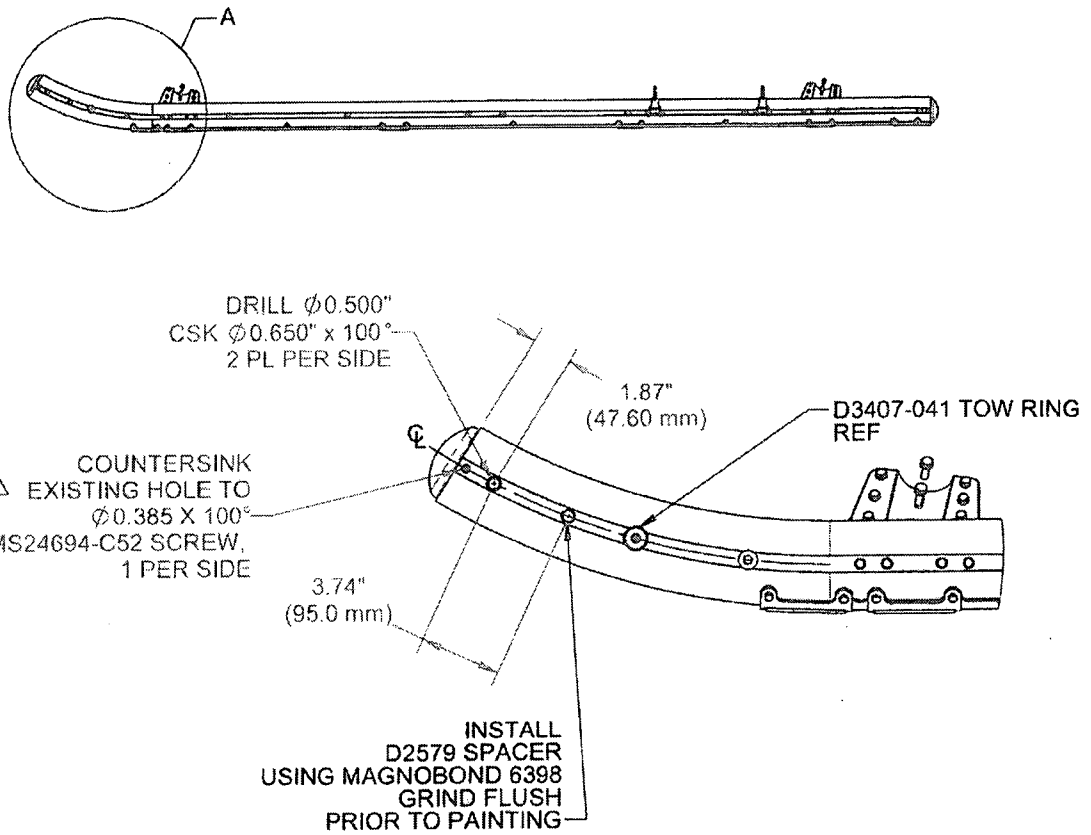
4.0 WEIGHT AND BALANCE

This modification has negligible effect on weight and balance.

REV.	DESCRIPTION	BY	DATE
B	ADD INSTRUCTION TO REMOVE EXISTING CAP MOUNTING HARDWARE AND REPLACE WITH COUNTERSUNK SCREWS	DB	13.02.20
A	NEW ISSUE	RF	12.02.03

DESIGN	RF	**DART AEROSPACE USA, INC.**	
DRAWN	DB	KENT, WA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9594	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FWD GROUND HANDLING SPACER KIT	NTS
DATE	13.02.20		

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DETAIL A
LH SKIDTUBE
LOOKING INBOARD

FIGURE 1. MODIFIED D119-646-XXX SKIDTUBE

DESIGN	RF	**DART AEROSPACE USA, INC**	
DRAWN	DB	KENT, WA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9594	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FWD GROUND HANDLING SPACER KIT	NTS
DATE	13.02.20		

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Linda Lacelle

From: Mike Petsche
Sent: March-06-13 10:27 AM
To: Linda Lacelle; David Shepherd
Cc: Eric Downing
Subject: RE: 119 skids

Yeah that's pretty much the gist of it. The DSI had been for A-W to do the mod for the aircraft that is here at the show. But for any stock/WIP you have, do exactly what you just said.

Dave (Bain) has updated the dwgs. An ECN should not be terribly far off. (I'm checking with him now to see where it is)

From: Linda Lacelle
Sent: Wednesday, March 06, 2013 7:36 AM
To: David Shepherd
Cc: Mike Petsche; Eric Downing
Subject: RE: 119 skids

Thx David. I'm a bit confused though, this DSI is for the customer when in the field correct? All we have to do is countersink the holes for the cap, re-alodine, touch up, replace cap with screw, correct?
LL

From: David Shepherd
Sent: March-05-13 2:32 AM
To: Mike Petsche; Linda Lacelle
Subject: RE: 119 skids

ECN B-534

Linda,

I am good with modifying the front end of the 119 skidtubes to the attached DSI.

Regards,
David

From: Mike Petsche
Sent: March-04-13 10:17 AM
To: Linda Lacelle; David Shepherd
Subject: FW: 119 skids

fyi

From: David Bain
Sent: Monday, March 04, 2013 12:06 PM
To: Mike Petsche
Subject: RE: 119 skids

Mike,